

Date: Thursday, 8/30/2007 3:49:50 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	34352		
Estimate Number	12785		
P.O. Number	N/A	Part Number	D356411
This Issue	8/30/2007	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D3564 REV C
First Issue	N/A	Project Number	N/A
Previous Run	33799	Drawing Revision	C
Written By		Material	N/A
Checked & Approved By	<u>TD 07-08-31</u>	Due Date	9/18/2007
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM	Qty:	10
Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet 
Comment: Qty.: 0.9177 sf(s)/Unit Total : 18.3540 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: M10530 18 07-09-01		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ****(D3564-1F)**** Dwg Rev: C Prog Rev: C 18 07-09-01		
2-Deburr if necessary 18 07-09-12		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 18 07-09-01		
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK 18 07-09-12		
5.0	BRAKE NC.	NC BRAKE 
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8157 8157		
8157 07/09/19		

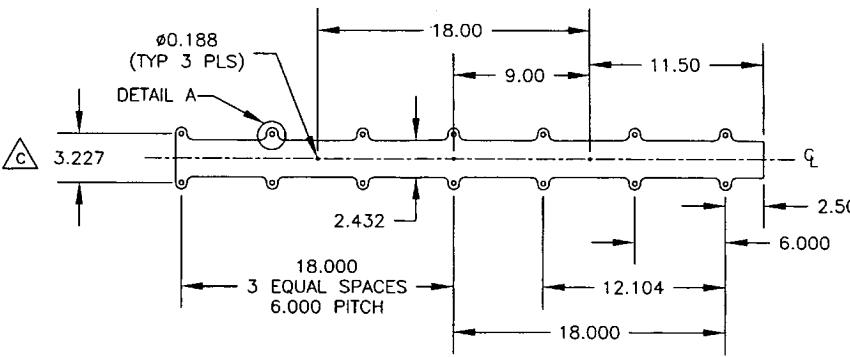
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

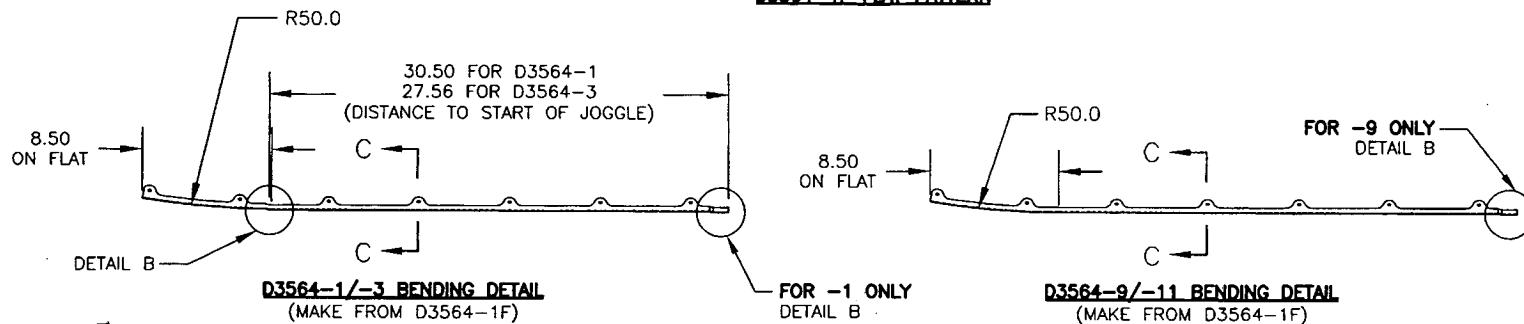
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**



2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

**D3564-1/-3/-9/-11 WELDING DETAIL**

NO. 34352  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
ENGINEERING  
RETURN TO  
SHOP COPY

**UNDER REVIEW**  
07.03.14 CB  
adding wearplate  
CB 07.08.30

**RELEASED**  
07.06.28

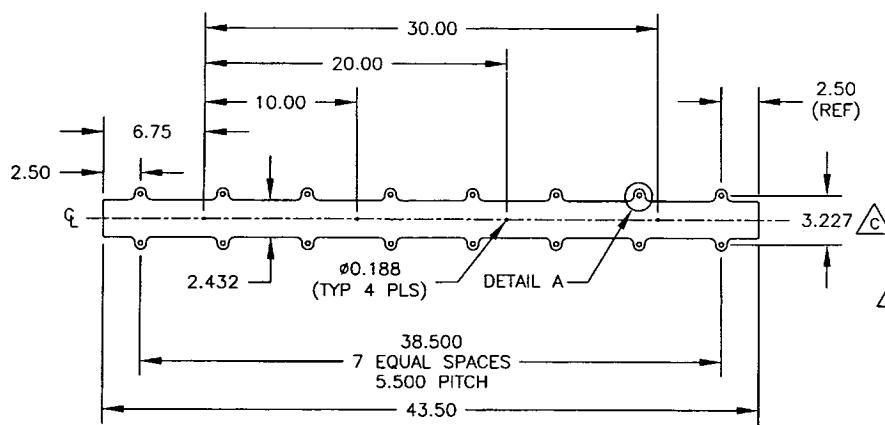
**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

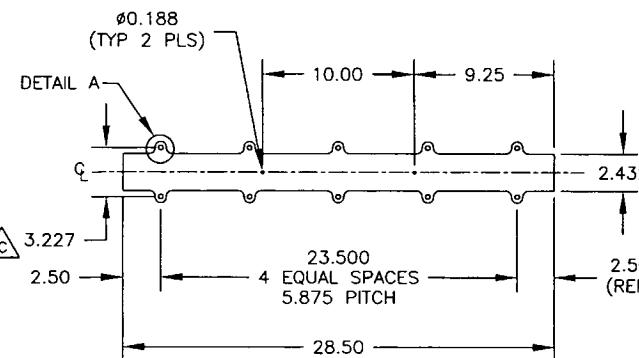
C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
RH	PH	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
H	H	D3564
DATE		REV. C
07.04.17		SHEET 1 OF 2
		SCALE
		WEARSHOE
		1:8

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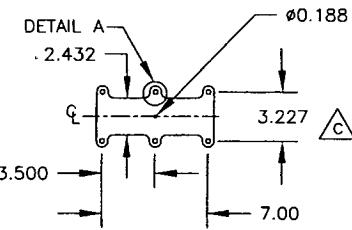
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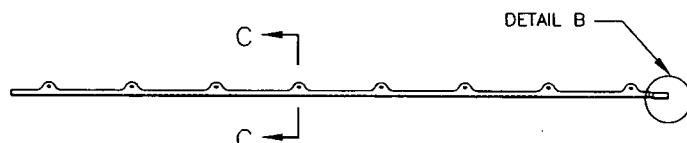
**D3564-5F FLAT PATTERN**



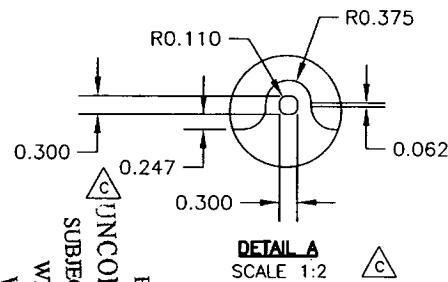
**D3564-7F FLAT PATTERN**



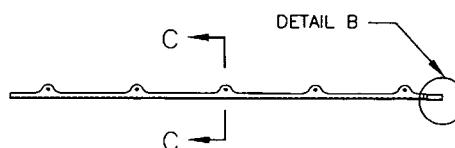
**D3564-13F FLAT PATTERN**



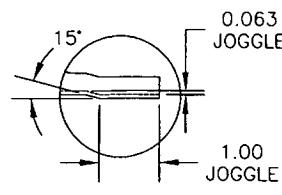
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



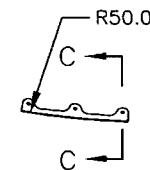
**DETAIL A**  
SCALE 1:2



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**DETAIL B**  
SCALE 1:2

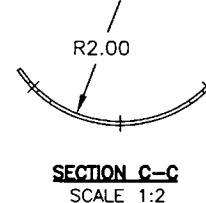


**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)

07.08.30  
CB

**UNDER REVIEW**

07.08.21 CB  
adding wearplate



**SECTION C-C**  
SCALE 1:2

NO. 34352  
WORK ORDER  
RETURN TO  
ENGINEERING  
SHOP COPY  
WITHOUT NOTICE  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

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DESIGN	DRAWN BY	<b>DART</b>
CHECKED	APPROVED	DRAWING NO.
		D3564
DATE		TITLE
07.04.17		WEARSHOE

DART AEROSPACE LTD.  
HAWKSBURY, ONTARIO, CANADA  
REV. C  
SHEET 2 OF 2  
SCALE  
1:8

DART AEROSPACE LTD	Work Order:	<del>243</del>
Description: WEAR PAD	Part Number:	P 3564-11
Inspection Dwg:	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	CR	Prototype Approval:	N/A
Date:	07-09-01	Date:	07/09/04	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

1.  $\sin \theta = \frac{1}{\sqrt{2}}$   
2.  $\cos \theta = \frac{1}{\sqrt{2}}$   
3.  $\tan \theta = 1$   
4.  $\cot \theta = 1$   
5.  $\sec \theta = \sqrt{2}$   
6.  $\csc \theta = \sqrt{2}$